

Date: Tuesday, 15/07/2008 9:15:22 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	STRUT
<b>Job Number</b> :	40489		
<b>Estimate Number</b> :	11022		
<b>P.O. Number</b> :		<b>Part Number</b> :	D27491
<b>This Issue</b> :	15/07/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2749 REV C
<b>First Issue</b> :	1/1	<b>Project Number</b> :	N/A
<b>Previous Run</b> :		<b>Drawing Revision</b> :	C
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	JUD 08.15.08	<b>Due Date</b> :	24/07/2008
<b>Comment</b> :	Est: C 00.05.19 Added inspect level 8, removed P/O for powder coating EC		
		<b>Qty:</b>	10
		<b>Um:</b>	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00750	6061-T6 Bar .75" x .75"
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**Comment:** Qty.: 0.8400 f(s)/Unit Total : 8.4000 f(s)

6061-T6 Bar .75" x .75"

Material: 3/4" x 3/4" bar 6061-T6

Batch: M107387

RQ 08/07/17

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blank: 9.60" long

29 08/07/17

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2749-1

RQ 08/07/17

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

RQ 08/07/17

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

SS 08/07/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:15:22 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 40489

Part Number: D27491

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

~~Tumble and Debur~~ *N/A* *08-07-17*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1 *BR* *08/07/21* *(100)*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP *08/07/21* *(10)*

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: *3:30*

OVEN TEMPERATURE: *320 °F*

FINISH TIME: *4:00* *M-L* *08/07/21* *(10x)*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION *BR* *08-07-22* *(10)*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57198* *08/07/22* *(10)*

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE *08/07/23* *MF* *08-07-22*

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

06.07.1

<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
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Measured by: <i>22</i>		Audited by: <i>S.S</i>		Prototype Approval: N/A	
Date: <i>08/07/17</i>		Date: <i>08/07/17</i>		Date: N/A	

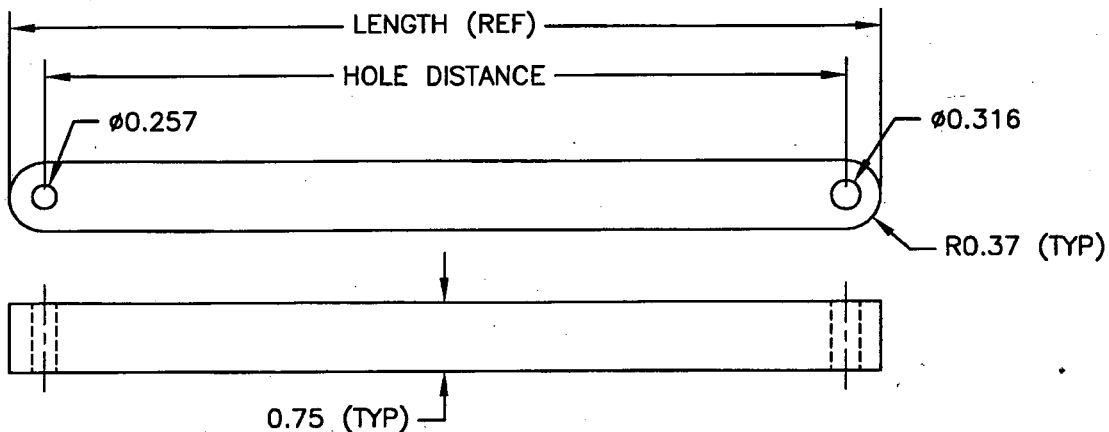
Rev	Date	Change	Revised by	Approved
A	05.06.28	New Issue	KJ/JLM	
B	07.02.19	Dwg revision update	KJ/JLM <i>JA</i>	<i>Chd</i>

**DART**

DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2749	REV. C SHEET 1 OF 1
DATE 07.02.13		TITLE STRUT	SCALE NTS
A	99.09.24	NEW ISSUE	
B	99.10.08	REMOVED LIGHTENING HOLES	
C	07.02.13	ADD D2749-9/-11	

RELEASED

07.02.14



DART P/N	HOLE DISTANCE	LENGTH (REF)
D2749-1	8.700	9.45
D2749-3	7.890	8.64
D2749-5	12.630	13.38
D2749-7	10.340	11.09
D2749-9	7.000	7.75
D2749-11	5.188	5.94

**D2749-1/-3/-5/-7/-9/-11 STRUT****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T6512/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART MATERIAL SPEC M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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NO. *40489*

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